

Date: Wednesday, 3/14/2007 3:28:33 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 205 SKIDTUBE "I" BEAM		
Job Number	: 31213					
Estimate Number	: 10346					
P.O. Number	: N/A			Part Number	: D2596	
This Issue	: 3/14/2007		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: D2596 REV C	
First Issue	: 3/14/2007		Type	: LANDING GEAR		
Previous Run	: 31110			Project Number	: N/A	
Written By	:			Drawing Revision	: C	
Checked & Approved By	:			Material	: N/A	
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D			Due Date	: 3/23/2007	
					Qty:	6 Um: Each
					M	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n -I' Beam Web 4"	
 Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion B25751			
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
 Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr			
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
 Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
 Comment: INSPECT WORK TO CURRENT STEP			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: LG			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/31/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

107/03/22

Job Completion



107/03/22

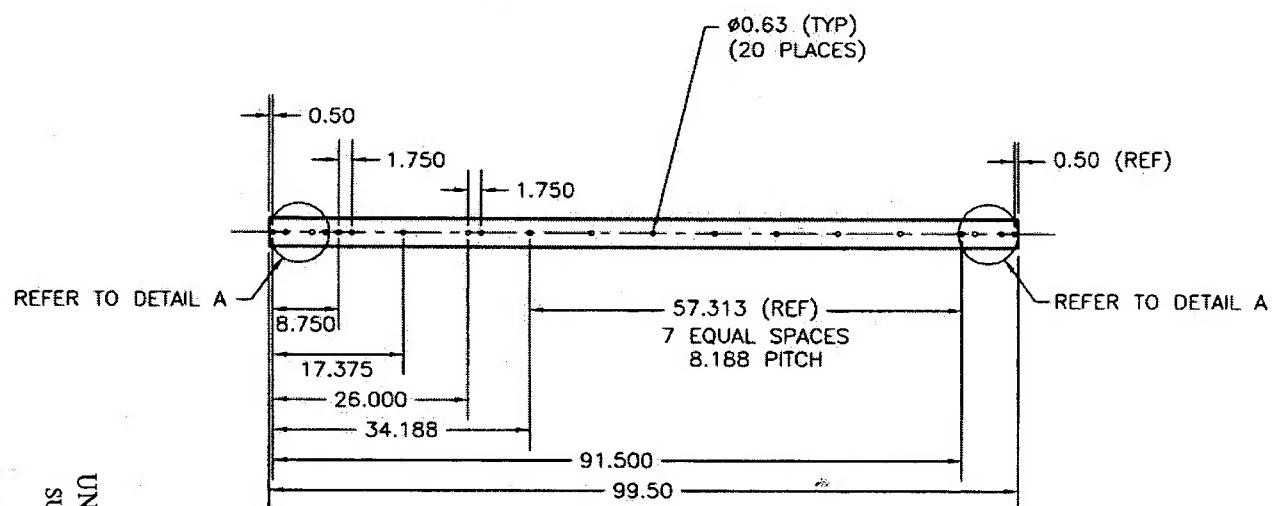
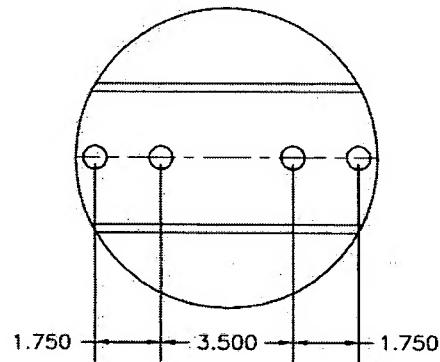
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A
SCALE 5:24



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31213

RELEASED
18/01/17 DS

DESIGN <i>W4</i>	DRAWN BY <i>GW</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>TM</i>	APPROVED <i>GW</i>	DRAWING NO. D2596	REV. C	SHEET 1 OF 1
DATE 98.09.14	TITLE 205 WEB	SCALE 1:24		
A 96.09.16	NEW ISSUE			
B 97.07.23	Ø 0.63 HOLE WAS Ø 0.56			
C 98.09.14	INCORPORATED DEO 9097			